

Work Order ID 73460***73460***

Page 1

Tuesday, April 24, 2012 3:27:53 PM

Item ID: D3538-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Bracket

Start Date: 8/31/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3538

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 1.500" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA651 and Dwg D35382-Deburr

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Work Order ID 73460

Tuesday, April 24, 2012 3:27:53 PM

73460

Page 2

Item ID: D3538-1

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Bracket

Start Date: 8/31/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

H-A 12/05/02

8

φ

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8

φ

12/05/02

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

11-30

8x

φ

M-F

12/05/02

m121134

Work Order ID 73460***73460***

Page 3

Tuesday, April 24, 2012 3:27:53 PM

Item ID: D3538-1 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Hinge Bracket
Start Date: 8/31/2011 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 9/16/2011 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>S4</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten notes and signatures:
- Under 160: S4
- Under 170: S4
- Under 180: MCS 12/05/02
- Under 180: ME
- Under 180: 12-05-02

Picklist Print

Tuesday, April 24, 2012 3:27:52 PM

Page 1

Work Order ID: 73460

Parent Item: D3538-1

Parent Item Name: Hinge Bracket

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-10.03 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.250 6061-T6 Bar 1.25 x 1.25		Purchased	No			100	f	28.7400	0.19	1.6			

Location

Loc Qty

Loc Code

MAT004

28.74

→ 119318

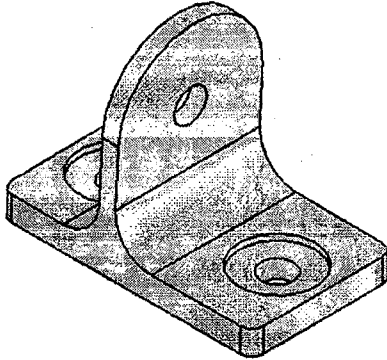
28.74

PD 12/04/26 .

1.6

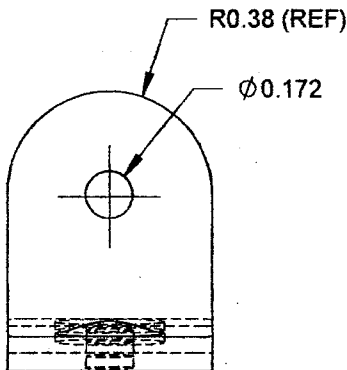
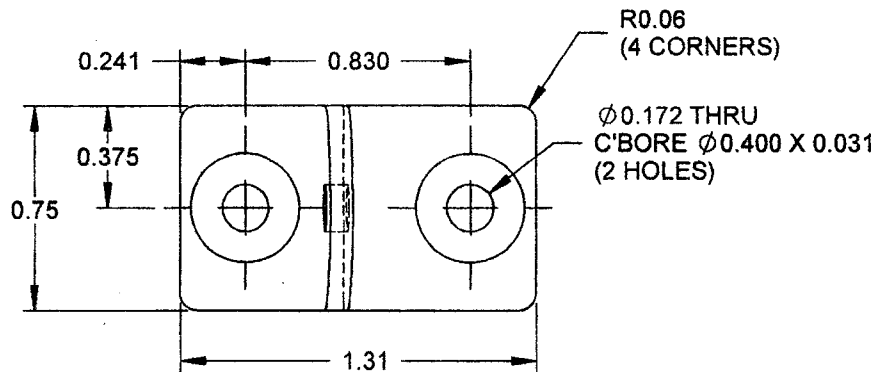


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

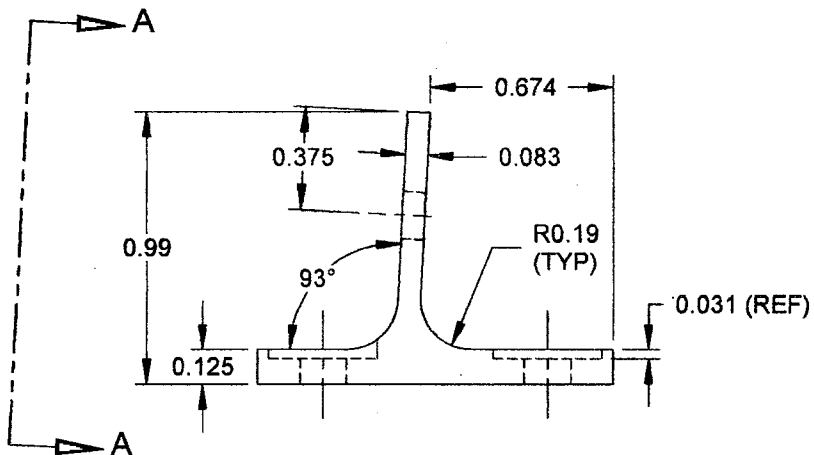


RELEASED
06.10.13

w/p 73460



AUXILIARY VIEW A



D3538-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order:	734/60
Description: Hinge Bracket		Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.752	/			
0.375	+/-0.010	.376	/			
0.241	+/-0.010	.245	/			
0.830	+/-0.010	.828	/			
Ø0.172	+0.005/-0.001	.172	/			
Ø0.400	+0.006/-0.001	.399	/			
0.031	+/-0.010	.026	/			
1.31	+/-0.030	1.315	/			
0.375	+/-0.010	.375	/			
0.99	+/-0.030	.988	/			
0.125	+/-0.010	.124	/			
R0.19	+/-0.030	.187	/			
0.083	+/-0.010	.085	/			
93°	+/-0.5°	93°	/			
0.674	+/-0.010	.667	/			
R0.38	+/-0.030	.375	/			
Ø0.172	+0.005/-0.001	.171	/			

Measured by: <i>DR</i>	Audited by: <i>B.A.</i>	Prototype Approval:	N/A
Date: <i>12-5-1</i>	Date: <i>12/05/02</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM <i>AK</i>	<i>AK</i>